

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2017-148

Date Opened: 01 September 2017

Title: Fabrication

Aircraft OEM: All

Aircraft Model: All

Product Type: Beam

Product Model: Guide Tube

Quantity: 200

Work Order Contents

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
N/A
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
69830	3	Forward Beam	JC

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

208
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
JC
JC
JC
JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: C. Brander/J. Clarke

Sign: JH Clarke

SCA: AD02

Date: 02-Oct-17

ICC / Dual Inspection performed by:

Print: N/A

Sign: JH Clarke

SCA:

Date:

Work Order closed by:

Print: Jeff Clarke

Sign: JH Clarke

SCA: AD02

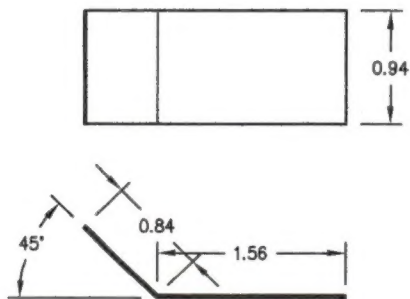
Date: 03-Oct-17

Approved Manufacturing Facility 73-04

Form 20.0/03

Rev. Original 23 Sep 2014

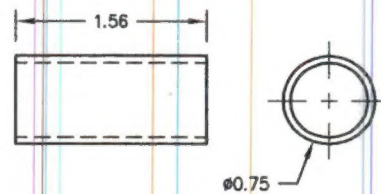
①① STRAP



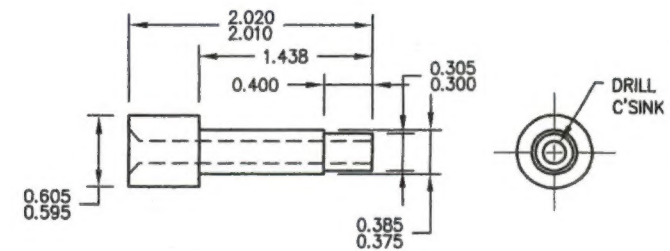
①① CAP

①① BLOCK

cut @ 1.6



①① GUIDE



①① STOP





Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Unserviceable

Remarks

undersized

DISCARDED 02 OCT 2017 JK.



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AMF 73-04

Nomenclature: GUIDE TUBE QTY 4

Manufacturer: AERO DESIGN LTD.

Part No.: 69830-11 Serial / Batch No.: 1015073

TTSN: N/A TSO: N/A Rem.: N/A

Removed From: N/A

Reason For Removal: UNDER SIZE

A/C Hours at Removal: N/A WO.# 2017-148

Signature: [Signature]

Date: Oct 2 2017 Lic. No. / SCA _____

Unserviceable



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AMF 73-04

In Process

Remarks

-10 for production 12 september 2017 AD-10 KB completed ft.
-4 undersized 2 october 2017 CB



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AMF 73-04

Nomenclature: GUIDE TUBE No. of pieces: 212

Manufacturer: AERO DESIGN LTD.

Part No.: 69830-11 Serial/Batch No.: PD 15073

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-148

Remaining Tasks to be Performed: TURN TO LENGTH, DEBURR

INSPECT

Signature: JH Cel.

Date: 01 SEPT 2017 Lic. No. / SCA ADD2

In Process

BUSHING/TUBE/GUIDE/THREADED LUG

General

These general instructions apply to bushings, tubes and similar round components used for Aero Design cargo baskets, mounting beams, and other products. Refer to the drawing, at the current revision, for dimensions and details. Selected drawings with applicable parts, drawings not listed may also apply:

69830 – Bell 206L/407 Mounting Beam
76630 – Bell 206L/407 High Mounting Beam
78633 – Airbus AS350 Aft Beam
78634 – Airbus AS350 Forward Beam
49215 – Lid Prop Bushing
49216 – Lid Prop Bushing

76423 – Airbus AS350 Attachment Hoop
94023 – Airbus AS350 XL Attachment Hoop
82715 – Airbus AS350 Short Step Assembly
82733 – Airbus AS350 Short Step Bracket
36274 – Handle Lever Bushing
36275 – Handle Support and Bushing

Work Order: 2017-148

Batch Quantity: 200 212 JC. -4

Complete
(initial or SCA #)

Date Open: 01 SEPT 2017

Part Number: 69830-11

GUIDE TUBE

1. Cut stock material:

- Enter material PO:
- Cut stock to length, + 0.03-0.06".
- Tag in-progress parts and place on in-progress shelf in machine shop.

PO: 15073

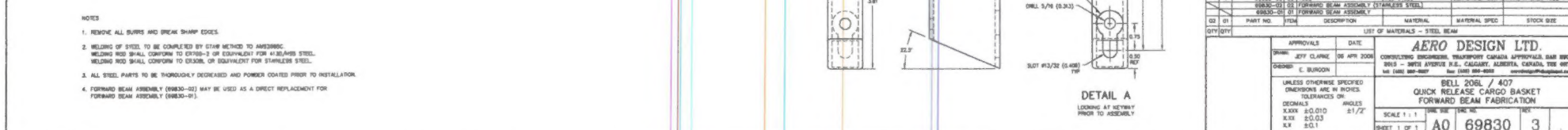
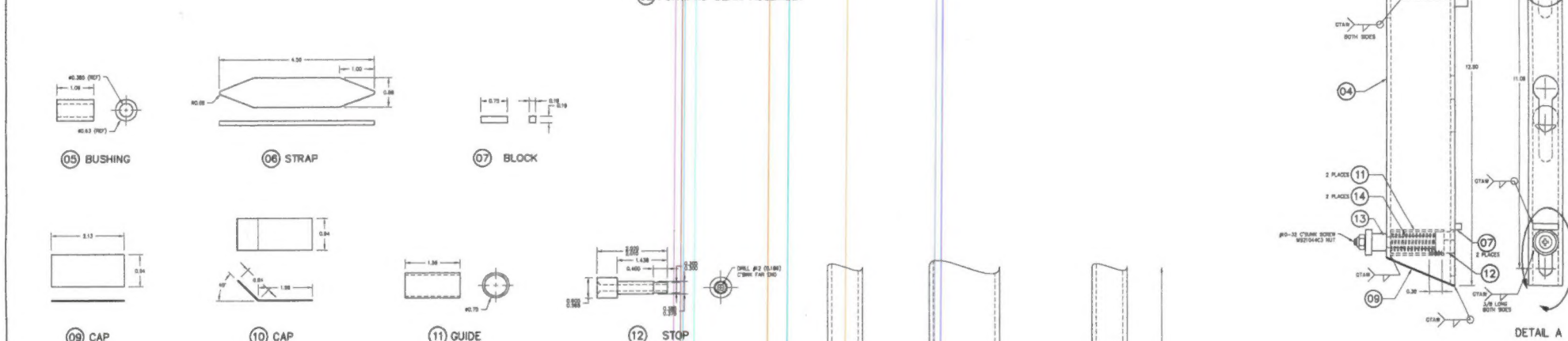
2. Turn stock material:

CAUTION: Using a lathe requires training and is not to be undertaken without adequate instruction and knowledge of the processes and settings involved. Do not attempt to fabricate parts on the lathe if you are unsure of what is required to safely produce the part.

Note: Not all steps may apply to all parts. Strike out any step(s) that does not apply.

Note: Feeds and speeds are recommended starting point for aluminum, steel, and stainless steel up to 1" in diameter using the appropriate inserts. Adjust for optimal performance and finish.

- Face one end flat @ 1000 RPM, cross feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Turn outside @ 1000 RPM, feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Centre drill and drill at 300 RPM (up to 5/16", reduce for larger sizes).
- Setup stop and face other end to length @ 1000 RPM.
- De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Tag complete parts.

[illegible][illegible]

1. 1990年12月1日以前

APPROVALS		DATE	AERO DESIGN LTD.	
BY: JEFF CLARK		06 APR 2008	CONSULTING ENGINEERS, TRANSPORT CANADA APPROVED, SAN DIEGO	
DESIGNED: E. BURSON			1305 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2C 1P5	
			tel: (403) 242-8827 fax: (403) 242-8828 email: aerodesign@erpcanada.com	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS			BILL 208L / 407 QUICK RELEASE CARGO BASKET FORWARD BEAM FABRICATION	
ANGLES		TITLES		
21/2°		SCALE 1:1		
K/R ±0.010		SHEET 1 OF 1		
K/R ±0.03		A0 69830 3		
K/R ±0.1		NET		